

Work Order ID 52392

Tuesday, September 22, 2009 11:17:32 AM



Page 1

Item ID: D206-642-441

Accept



Setup Start



Revision ID: F

Stop



Item Name: Replacement Skidtube

Start Date: 9/23/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

09-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Deburr Fwd edge of tube 2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650 3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. 4-Aluminum Rod 5-Grind weld flush to cap on top surface only. 5-Cut af

m109213
mm 999

BE 09/10/13

120

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

1 Ø - AWM 7-10-14

B-52392

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.
A/R Aluminum Rod _____

4-Grind weld flush to cap on top surface only.

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skid tube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

10/12/16

-AWM 9-10-14

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Start Date: 9/23/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start




Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC3- Inspect Part Finish Memo  9-10-14	0.00 0.00							
140 Skidtubes Skidtubes	Skidtubes Memo 1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid) 2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid) 3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer. 4-Bond D26	0.00 0.00							10 - AWM 9-10-13
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							2) Soliholis AWM 9-10-14

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Start Date: 9/23/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. <input type="checkbox"/> A/RAluminum Rod <u>m10123</u> <input type="checkbox"/> 2-Grind welds flush as per Dwg D2650. <input type="checkbox"/> 3-Counterbore 5/16" x								
									BE 09/10/15 - AWM 9-10-15
170 	HandFinishing	0.00							
HandFinish	Memo	0.00							
Hand Finishing	Install D2680-041 Nut Plate as per Dwg D2650								1 - AWM 9-10-20
180 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									

⇒ 09/10/20

Work Order ID 52392

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Item ID: D206-642-441

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Start Date: 9/23/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 => 5.0/10/20							
200 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00 BL 09-10-20							
210 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 7:15AM <input type="checkbox"/> OVEN TEMPERATURE: 7:45AM <input type="checkbox"/> FINISH TIME: 8:20PM	0.00 0.00 => 11 09/10/20							

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Tuesday, September 22, 2009 11:17:32 AM

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Start Date: 9/23/2009 Start Qty: 1.00

Required Date: 10/15/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

250

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-441 □ Location: _____ □ PPP Rev: PPR 52339

260

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

W 09-10-27

09/12/14

R 9/1/26

Picklist Print

Tuesday, September 22, 2009 11:17:31 AM

Page 1

Work Order ID: 52392

Parent Item: D206-642-441RevF

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 9/23/2009

Required Date: 10/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2620RevB		Manufactured	No			110	Each	19.0000	1.0000			
												
Skidtube, 206 Skidtube												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

19

45898

19

D2646RevC

Manufactured No

120

Each

56.0000

1.0000



Aft Cap

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

56

20208

0

43801

1

46327

6

48109

49

D2647RevF

Manufactured No

140

Each

29.0000

1.0000



Cap

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

29

10773

7

43846

22

1 BE 09/10/13

See attached

1 BE 09/10/13

Picklist Print

Page 2

Tuesday, September 22, 2009 11:17:31 AM

Work Order ID: 52392



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 9/23/2009

Required Date: 10/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2654-7RevE1 		Manufactured	No			160	Each	0.0000	1.0000			
Web CCR264SS3-3 		Purchased	No			170	Each	271.0000	2.0000			
Cherry Rivet												

B-52801 (1*) AWM 9-10-14

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	271	
111548	56	
111827	115	
112314	100	

AWM 9-10-20 (2)

D2649RevB1 	Manufactured	No
Cross Bolt Spacer		

170	Each	711.0000	23.0000
-----	------	----------	---------

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
LG	83	
51529	83	
Main Warehouse		
ST	628	
36013	5	
47112	383	
48271	240	

23 BE 09-10-15

Picklist Print

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Tuesday, September 22, 2009 11:17:31 AM

Work Order ID: 52392



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 9/23/2009

Required Date: 10/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2680-041RevB1 Manufactured No

170

Each

79.0000

1.0000



Nut Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

79

33061

14

44086

65

ALS4-1032-130 Purchased

No

230

Each

5,439.000

60.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5439

110511

5439

AWM 9-10-19

(1)

112770

XCOO m009110121

Picklist Print

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Tuesday, September 22, 2009 11:17:31 AM

Work Order ID: 52392



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 9/23/2009

Required Date: 10/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD10L Purchased No 230 Each 6,445.000 62.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6445

101291

16

104885

153

105793

236

109632

1040

110983

5000

KLED MD 09/10/21

Picklist Print

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Tuesday, September 22, 2009 11:17:31 AM

Work Order ID: 52392



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 9/23/2009

Required Date: 10/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416 		Purchased	No			230	Each	7,793.000	1.0000			
Washer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7793	
102929	2	
105906	4	
106277	2	
107321	23	
107939	114	
108161	553	
108827	31	
109249	69	
110523	340	
111279	101	
111916	1959	
112314	4595	
16941	0	

21 mo 09/10/21

CR3212-4-03

Purchased

No

230

Each

314.0000

2.0000



Cherry Rivet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	314	
111359	96	
112314	200	
15984	18	

AWM 9-10-20 (2)

Tuesday, September 22, 2009 11:17:31 AM

Shop Packet Print

Page 5

Picklist Print

Tuesday, September 22, 2009 11:17:32 AM

Work Order ID: 52392



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 9/23/2009

Required Date: 10/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2648-3RevD

Manufactured

No

230

Each

22.0000

6.0000



Wearpad

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

12

45316

12

Main Warehouse

ST

10

21711

0

40937

10

N/A see attached

D2651-1RevB

Manufactured

No

230

Each

403.0000

22.0000



Plug

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

403

43990

125

45490

28

51530

250

X22 mo 09/10/21

X22 mo 09/10/21

Picklist Print

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Tuesday, September 22, 2009 11:17:32 AM

Work Order ID: 52392

Parent Item: D206-642-441RevF

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 9/23/2009

Required Date: 10/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2651-3RevB		Manufactured	No			230	Each	1,035.000	22.0000			
												
O-Ring												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

1035

43849

3

46114

1032

D2656-15RevD

Manufactured

No

230

Each

13.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

Return 2009

45245

Main Warehouse

ST

45245

7

Y22 mo 09/10/24

WMA

Picklist Print

Tuesday, September 22, 2009 11:17:32 AM

Work Order ID: 52392



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 9/23/2009

Required Date: 10/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2656-23RevD		Manufactured	No			230	Each	20.0000	1.0000			
Wearshoe												

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST

20

34397

1

43407

7

51468

12

230

Each

18.0000

1.0000

D2656-37RevD

Manufactured

No



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST

18

44550

13

46497

1

51469

4

Picklist Print

Tuesday, September 22, 2009 11:17:32 AM

Work Order ID: 52392



Parent Item: D206-642-441RevF



Parent Item Name: Replacement Skidtube

Start Date: 9/23/2009

Required Date: 10/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3429-1RevA		Manufactured	No			230	Each	22.0000	1.0000			
Wearpad												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

22

44169

2

44579

20

MS27039-1-08

Purchased

No

230

Each

3,333.000

62.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3333

110467

192

110552

1141

110835

2000

MS27039-4-06

Purchased

No

230

Each

77.0000

1.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

77

109061

77

SEE ATTACHED

Status	Item ID	Rev	Name	Start Date	Quantity	UOM	Price	Disc %	Net Price	Offset	Offset D	Typ	1 Per	Orch	to Win	Core	Last I
✓	D2620	B	Skidtube, 206 Skidtube	1/01/08	1....	Ea	110	0	0.			0	0	MRP			6/0...
✓	D2646	C X1	Aft Cap B48109	1/01/08	1....	Ea	120 230	0	0.			0	0	MRP			6/0...
✓	D2647	F	Cap	1/01/08	1....	Ea	140	0	0.			0	0	MRP			6/0...
✓	D2654-7	E1	Web	1/01/08	1....	Ea	160	0	0.			0	0	MRP			6/0...
✓	D2680-041	B1	Nut Plate	1/01/08	1....	Ea	170	0	0.			0	0	MRP			6/0...
✓	CCR264SS3-3		Cherry Rivet	1/01/08	2....	Ea	170	0	0.			0	0	MRP			6/0...
✓	D2649	B1	Cross Bolt Spacer	1/01/08	23....	Ea	170	0	0.			0	0	MRP			6/0...
✓	D3536-15	A X1	Gasket B48159	10/21/09	1....	Ea	230	0	0.			0	0	MRP			10/...
✓	D3536-23	A X1	Gasket B477123	10/21/09	1....	Ea	230	0	0.			0	0	MRP			10/...
✓	CR3212-4-03		Cherry Rivet	1/01/08	2....	Ea	230	0	0.			0	0	MRP			6/0...
✓	D3537-3	C X1	Wearpad B35647	10/21/09	1....	Ea	230	0	0.			0	0	MRP			10/...
✓	AN960JD416	X1	Washer m108161	1/01/08	1....	Ea	230	0	0.			0	0	MRP			6/0...
✓	D3535-23	B X1	Wearshoe B48156	10/21/09	1....	Ea	230	0	0.			0	0	MRP			10/...
✓	D3537-1	C X6	Wearpad B51624	10/21/09	6....	Ea	230	0	0.			0	0	MRP			10/...
✓	D2651-1	B X22	Plug B43990	1/01/08	22....	Ea	230	0	0.			0	0	MRP			6/0...
✓	MS27039C1-08	X100	SCREW m19185	10/21/09	60....	Ea	230	0	0.			0	0	MRP			10/...
✓	MS27039-1-08	X2	Screw m110467	1/01/08	2....	Ea	230	0	0.			0	0	MRP			10/...
✓	D2651-3	B X22	O-Ring B46114	1/01/08	22....	Ea	230	0	0.			0	0	MRP			6/0...
✓	D3536-37	A X1	Gasket B47335	10/21/09	1....	Ea	230	0	0.			0	0	MRP			10/...
✓	ALS4-1032-130	X60	Insert m112772	1/01/08	60....	Ea	230	0	0.			0	0	MRP			7/2...
✓	MS27039-4-06	X1	Screw m109001	1/01/08	1....	Ea	230	0	0.			0	0	MRP			6/0...
✓	D3535-37	B X1	Wearshoe B47374	10/21/09	1....	Ea	230	0	0.			0	0	MRP			10/...
✓	AN960JD10L	X62	Washer m1091632	1/01/08	62....	Ea	230	0	0.			0	0	MRP			6/0...
✓	D3535-15	B X1	Wearshoe B48155	10/21/09	1....	Ea	230	0	0.			0	0	MRP			10/...

Location/Lot Activity

December 15, 2009 3:01:43 PM

Page 1 of 1

Criteria : All Items All Locations Lot: 52392 All Transaction Types All Dates Report on Locations & Lots

Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost
Issue	D206-642-441 RevF / Replacement Skidtube	Main Warehouse FG	52339	FAUT01		8.0000		1.0000		
					10/27/09	-1.0000	52392	-1.0000		-\$1,198.63
								-1.0000		-\$1,198.63
WIP Receipt	D206-642-441 RevF / Replacement Skidtube	Main Warehouse FG	52392	LACE01		7.0000		0.0000		
					10/27/09	1.0000	52392	1.0000		\$1,198.63
								1.0000		\$1,198.63

D206-642-441

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52392

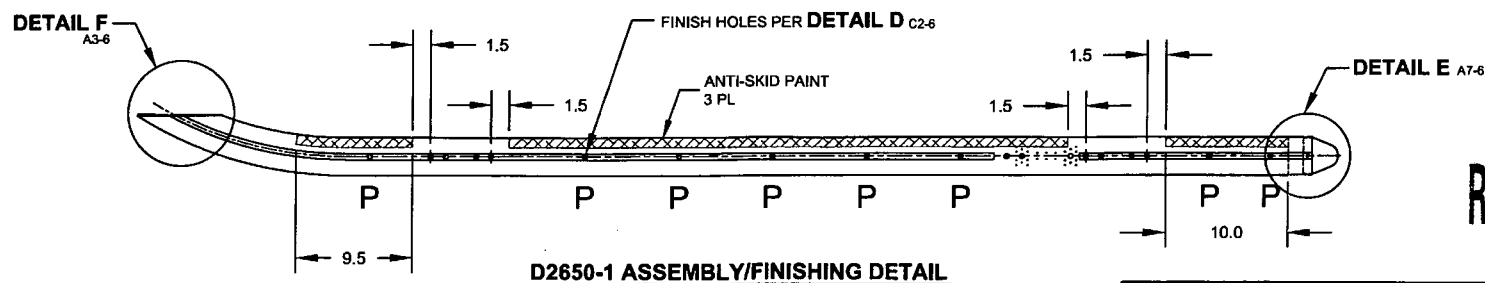
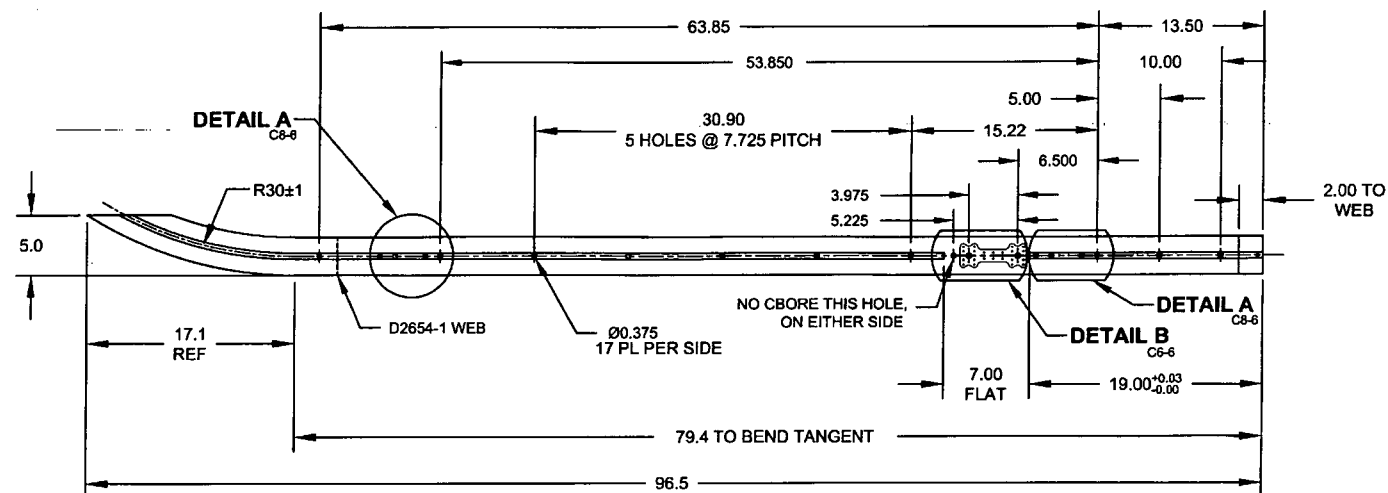
RELEASED
08-07-23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 230).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
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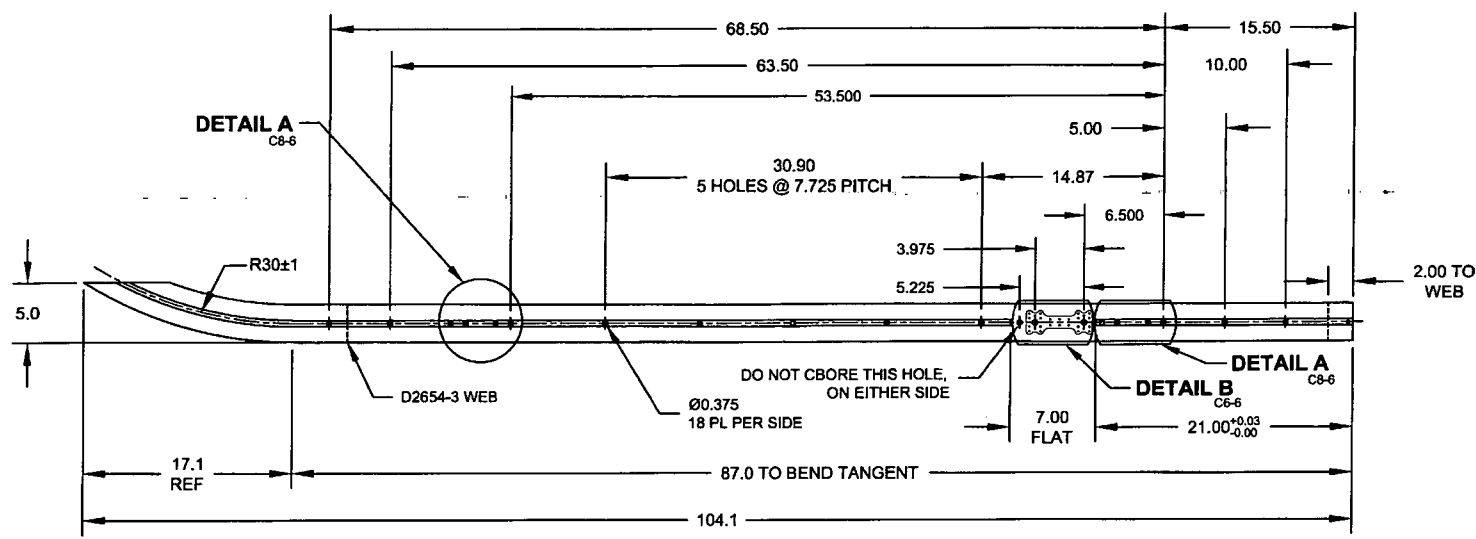
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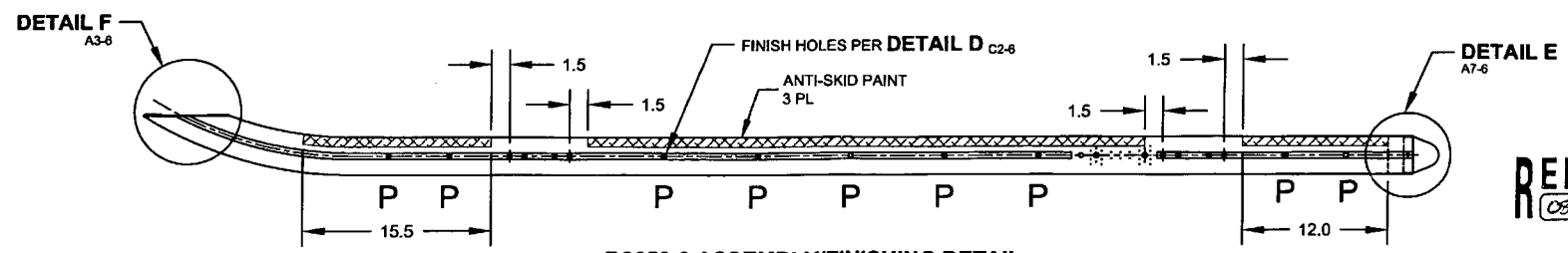
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D2650-3 BENDING/DRILLING DETAIL

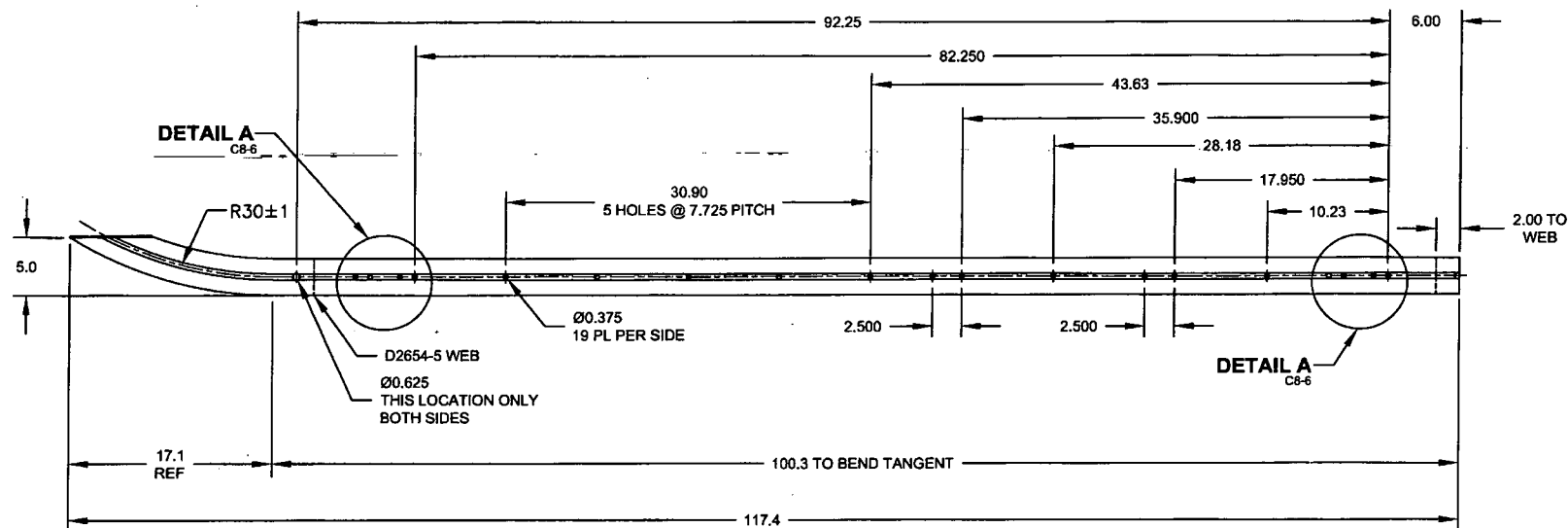


D2650-3 ASSEMBLY/FINISHING DETAIL

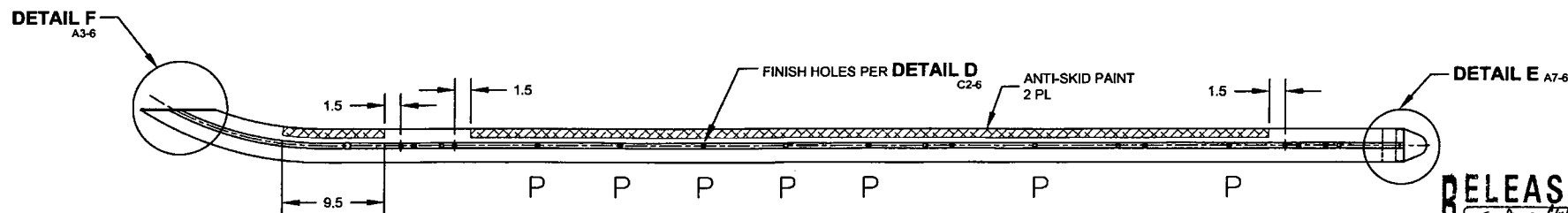
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D2650-5 BENDING/DRILLING DETAIL

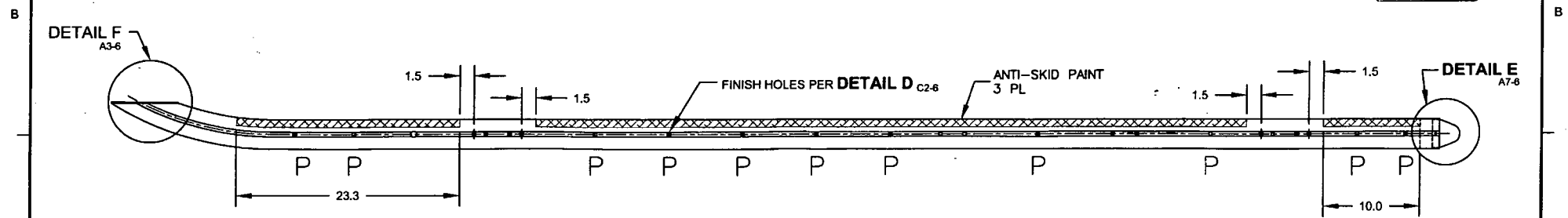
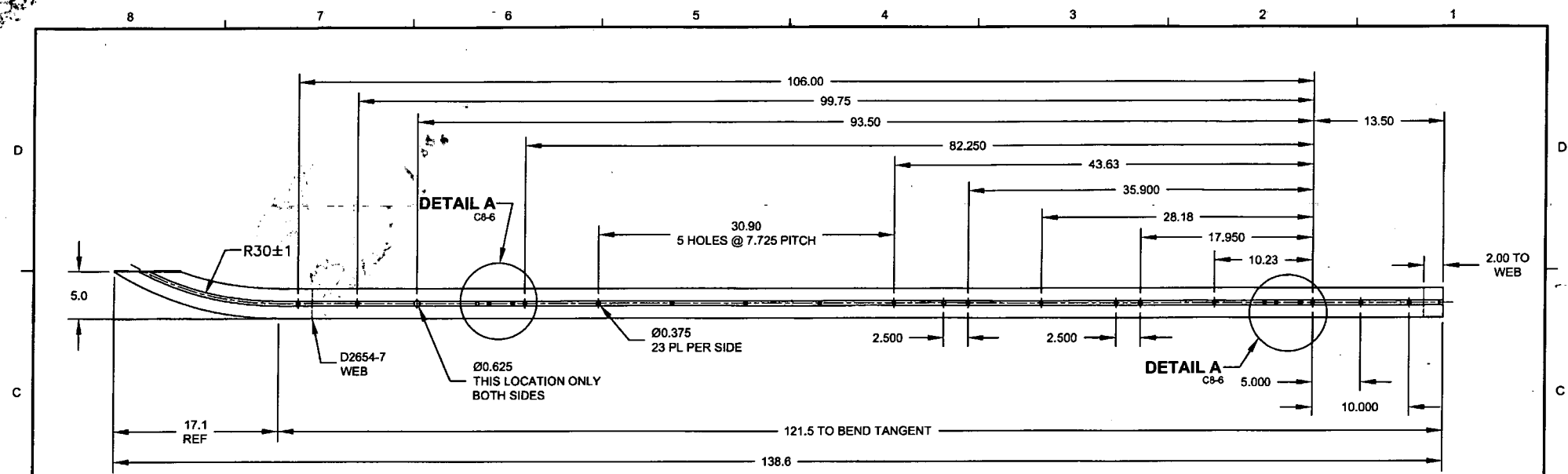


D2650-5 ASSEMBLY/FINISHING DETAIL

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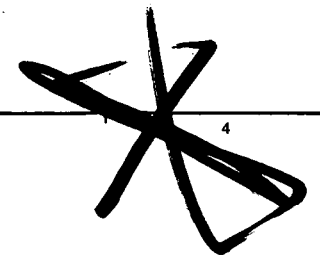
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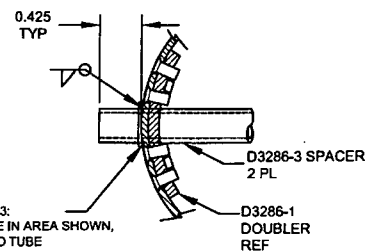
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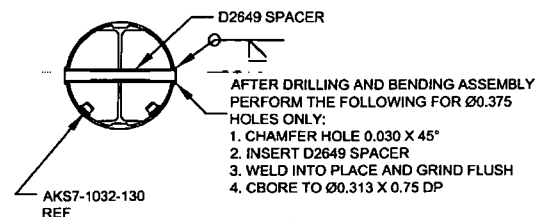
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SECTION C-C C7-6

SCALE NONE



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO 0.500
 4. ENLARGE HOLES IN TUBE TO 0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR 0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORER TO 0.313 X 0.75 DP

DETAIL D

FOR 0.375 HOLES ONLY

SCALE 3X

B4-2
B4-3
B4-4
B4-5

DETAIL F NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

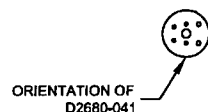
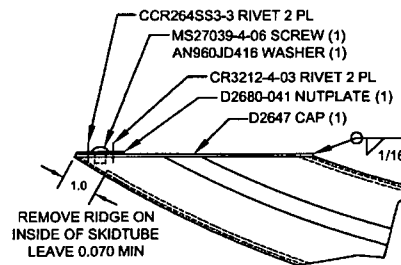
NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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05-09-2013

DETAIL F

SCALE NONE

B8-2
B8-3
B8-4
B8-5

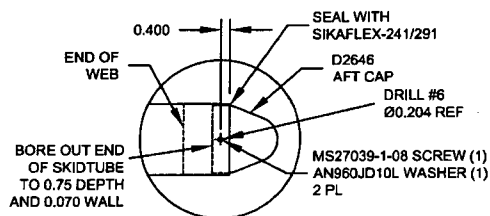


REMOVE RIDGE ON INSIDE OF SKIDTUBE
LEAVE 0.070 MIN

DETAIL E

SCALE 2X

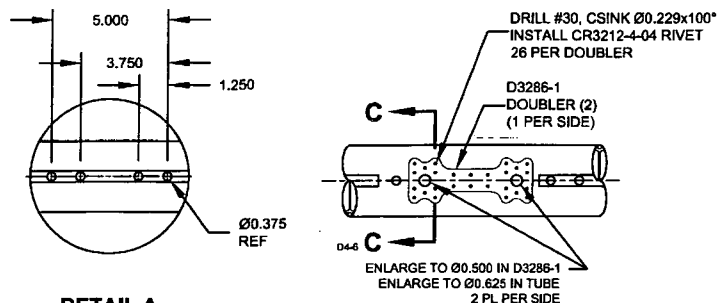
B2-2
B2-3
B1-4
B1-5



DETAIL A

SCALE 2X

C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D8-5



DETAIL B

SCALE 2X

C3-2
C3-3

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NO. 211

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 52411
Part number: D206-642-541
Description: 206 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pct. Paul Date of Test Coupon 09-10-09

Welder Barclay Elliott Date of Test Coupon 09-10-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld